

Work Order ID 144694

April 21, 2016 4:20:55 PM

144694

Page 1

Item ID: D350-589-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Side Door Latch Modification

Start Date: 5/13/2016 Start Qty: 1.00

Required Date: 5/20/2016 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS Date: APR 22 2016 Tooling:

Run Start

NR1

QC: Date: SPC (Y/N):

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
INN-D350-589	E								
100	Document Control		DAS 6						
	DOCUMENT CONTROL	0.00	9-89						
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type label as per PPP D350-589-011 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.03							
Quality Control									

MAY 08 2016

MLS 16-05-10

DAS
27
9-89

16/5/11

DAS
6
9-89

MAY 08 2016

DAS
27
9-89

16/5/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 144694

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Page 2

Item ID: D350-589-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side Door Latch Modification

Start Date: 5/13/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per QSI 014 Location :FG022								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.10							
Quality Control									

6X

DAS

27

9-59

10/5/11

2x sold
4x FG022

MW

MAY 11 2016

SA 2016 5 11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

April 21, 2016 4:20:55 PM

Work Order ID: 144694

144694

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP F02.08.29Removed D2587 PlugKJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2237 Striker Plate		Manufactured	No			105	Each	6.0000	3	2 18			DAS 28 9-89
D2237									**	144 871			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			MAY 09 2016
					ST004			6					
					140960			6		6			
D2583 Latch Bracket		Manufactured	No			105	Each	0.0000	3	3 18			DAS 28 9-89
D2583									**	142873			
D2585 Latch Clamp		Manufactured	No			105	Each	59.0000	3	2 18			DAS 28 9-89
D2585									**	6 B140960			MAY 10 2016
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST008			59					
					142882			59		10 18			DAS 28 9-89

DQA: _____ Date: _____



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OTHER : ☐					

Picklist Print

April 21, 2016 4:20:55 PM

Page 2

Work Order ID: 144694

144694

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

D2586 Manufactured No

105 Each

64.0000

3

3/8

D2586

Door Latch

**

Location

Loc Qty

Loc Code

FG

12

119746

1

138048

2

139228

9

ST481

27

139228

2

140535

25

ST488a

25

141454

25

DAS 28
6 9-89
9-89

DAS
27
9-89

D2587 Manufactured No

105 Each

19.0000

1

1/6

D2587

Door Plug

**

Location

Loc Qty

Loc Code

ST008

19

142853

19

D2589 Manufactured Yes

105 Each

92.0000

1

1/6

D2589

Keys, Key Chain

**

Location

Loc Qty

Loc Code

ST008

92

132942

92

DAS 28
6 9-89
9-89

MAY 09 2016

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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☐ OTHER : _____					

Picklist Print

Page 3

April 21, 2016 4:20:55 PM

Work Order ID: 144694

144694

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-5

Purchased

No

105

Each

964.0000

6

30

MS20470AD4-5

RIVET, UNIVERSAL HEAD

**

DAS

DAS

28

9-89

6

9-89

Location

Loc Qty

Loc Code

GA

914

m133860

914

ST310

50

m133860

50

30

MS21042L3

Purchased

No

105

Each

1,588.000

3

30

MS21042L3

Nut

**

DAS

DAS

28

6

9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

782

m133790

3

m134360

779

ST303

706

m134039

12

m134360

694

18

MS27039-1-15

Purchased

No

105

Each

337.0000

3

30

MS27039-1-15

Screw

**

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

21

m127916

21

ST280

316

m132640

316

18

DAS
27
9-89

MAY 09 2016
DAS
9-89

April 21, 2016 4:20:55 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																									

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Work Order ID: 144694

144694

Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

105

Each

1,903.000

3 / 3 18

DAS

NAS1149D0363.J

Washer

**

28

9-89

Location

Loc Qty

Loc Code

GA

583

m134055

583

ST263

1320

m134370

320

m134606

1000

MAY 09 2016

DAS

6

9-89

DAS

27

9-89

DQA: _____ Date: _____



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52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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